Work Ordei Wednesday, Novel	r ID 64108 mber 24, 2010 1:12:31	' PM										Page 1		
Item ID: I	D3825-041			1	Accept					Setup	Start			
Item Name:	Rib Assembly (Basket End 1/24/2010 Start Qty 1/30/2010 Req'd Qt	y: 6.00				Cust Item I Customer:	D:				Stop			
	Process Plan:	H	Date:	11-24	Tooling: SPC (Y/N):		ate:		-	Run	Start Stop			
Sequence ID/ Work Center ID	Operation Description				Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp	
Draw Nbr	Revision Nbr													
D3825	Rev A													
	Large Fab				0.00				6					
Large Fab Large Fab		Memo 1- cut D382:	5-1 rib as per dv	vg D3825	0.00									
					T9438 jig and open to	finish size as per								
		3- c'sink hol	e as per dwg											
		4- remove id	lentification man	kings			12 - 01							

6- weld D2327-3 spacer bushing and D3759-1 bushing as per dwg D3825 A/R S.S. Rod Batch: 11585

7- grind bushing weld flush where indicated on dwg D3825

5- deburr

8- deburr if necessary

SAD

W/O:			V	ORK ORDER CHA	NGES						
DATE	STEP	PRO	OCEDURE CH			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
									3		
Part No	):	PAR #:	Fault Ca	tegory:	NCR:	Yes N	o <b>DQ</b>	A:	Date: _		
							losed: Date:				
NCR:			WORK OR	DER NON-CONFOR	RMANCE (	NCR)					
DATE	STEP	Description of NC		Corrective Action	Section B	N: 0		cation	Approval	Approval	
DAIL	SIEF	Section A	Initial Chief Eng	Action Descripti Chief Eng	on 3	Sign & Date	Secti	ion C	Chief Eng	QC Inspector	
				a							
						· · · · · · · · · · · · · · · · · · ·					

#### Work Order ID 64108

Wednesday, November 24, 2010 1:12:31 PM



Page 2

Item ID:

D3825-041

Accept

Setup Start

Stop



**Revision ID:** 

**Start Date:** 

**Item Name:** 

Rib Assembly (Basket End)

11/24/2010

Start Qty: 6.00

**Required Date:** 11/30/2010 **Req'd Qty:** 6.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan: Date:

QC: Date:

Memo

Memo

Tooling:

SPC (Y/N):

Date: Date: Run

Start

Stop



Sequence ID/ Work Center ID

130

Quality Control

Operation **Description** 

QC9- Inspect visual per QSI004- Fusion Welds

Set Up/ **Run Hours** 

0.00

0.00

Tool ID

Tool # Plan

Code

Accept Qty

Reject Reject Oty

Number

Insp. Stamp

140

OC

Quality Control

QC5- Inspect part completeness to step on W/O

150

Packaging Packaging

Identify as per dwg & Stock Location: WA

Memo

									<del></del>				
W/O:			WO	RK ORDER CHANG	ES								
DATE	STEP	PRO	OCEDURE CHAN	IGE		Ву	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
						ļ							
			····										
		PAR #:	Fault Categ	ory:	NCR	: Yes N	o <b>DQA:</b>	DQA: Date:					
	R	esolution:	Disposition	:	QA:	N/C Clos	sed:	Date: _					
NCR:			WORK ORDE	R NON-CONFORM	ANCE	(NCR)							
DATE	STEP	Description of NC			tion B	C: 0	Verification		Approval				
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C	Chief Eng	QC Inspector				
									-				

#### Work Order ID 64108

Wednesday, November 24, 2010 1:12:31 PM



Page 3

Item ID:

D3825-041

Accept

Setup Start



Revision ID:

Item Name:

Rib Assembly (Basket End)

**Start Date:** 

11/24/2010

QC:

Start Qty: 6.00

Req'd Qty: 6.00



**Cust Item ID: Customer:** 

Reference:

			_
A	nnro	างล	ls:

Process Plan:

Operation

Description

Date: Date: **Tooling:** 

SPC (Y/N):

Set Up/

**Run Hours** 

Date:

**Tool ID** 

Date:

Tool # Plan

Code

Start

Stop



**Required Date:** 11/30/2010

Sequence ID/ Work Center ID

160

QC

Memo

QC21- Final Inspection - Work Order Release

0.00

0.00

Run

Accept

Qty

Reject

Qty

Stop

Reject

Number

Insp. Stamp

Quality Control

W/O:			WORK ORDER CHANGES								
DATE	STEP	PRO	OCEDURE CHAN	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
							· ·				
						<u> </u>					
Part No		PAR #:	Fault Cate	gory:	NCR: Yes	No <b>DQ</b>	<b>A</b> :	Date: _			
	Res	olution:	Disposition	1:	QA: N/C C	losed:		Date: _			
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NC	R)					
DATE	CTED	Description of NC			n B	Verific	cation	Approval	Approval		
DAIL	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		ion C	Chief Eng	QC Inspector		
		. ,									
٠											

# **Picklist Print**

Wednesday, November 24, 2010 1:12:35 PM

Work Order ID: 64108

Parent Item:

D3825-041

Parent Item Name.

Rib Assembly (Basket End)



Start Date: 11/24/2010

Required Date: 11/30/2010

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A 08-12-01 new issue DD verified by:EC

	ponent Item ID/ Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D232 Space			Manufactured	No			100	Each	7.0000		(10.	12.07		···.
					<u>Locatio</u>	<u>n</u>	Loc (	<u>Qty</u>	Loc Code	1	B640		_ /	<b>3</b>
					WA			7		$\mathcal{I}$	3640	248-	>-(	\$
	•					58974		I		_		_		•
						60320		1			<b>X</b> 6	1		
D255	20.1					60952	• • • •	5			كالع	J		
			Manufactured	No			100	Each	25.0000		P/11	0.12.0	7	
Bushi	ing						•	0.		· ·	Y	·	•	
					Locatio	<u>n</u>	Loc		Loc Code			- B638	97/ ·	-(i)
					ST084	56042		3		_		- 42638	576-3	
					177.4	56942		3		_		_		
					WA	54072		22 9						
						63875		13		_		-		
M304	4TS0.750W.065		Purchased	No		03075	100	f	340.7473	2.125	13.4210	- 5		
	HE 198 HAR BOTH BERARD HER AN BOTH						.00		3 1011,1,11	HINKING .	SAP	10-	12 -	01
. <u>/</u>	3Q 1 40C . / 3X. / 3X. 003 W				Locatio	<u>n</u>	Loc	<u>Qty</u>	Loc Code		* 1			
					MAT		241.0	1115						
						112398		0				- . <b>-</b>	472	5 /
						115494	4.	4725		0 1	1.473	7 (1	( BE	318
						115593	236.5			. –		_	,	-,
					WA		99.73			, ,	N. 2.1 7.3	51m /	130	(30)
						115274		2185		0	4.4	<u> </u>	4,41d	ַ [לצוי
						115901	95	5.024		-	<b>200</b> 4	4737	(43)	16415
											•		_ /	

W/O:		WORK ORDER CHA	WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
				<del></del>						
		·								
Part No		PAR #: Fault Category:	NCR: Yes	No <b>DQ</b>	 А:	Date:				

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:	WORK ORDER NON-CONFORMANCE (NCR)								
	T	Deceriation of NC		Corrective Action Section B		Verification	Annuaval	Ammental	
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector	
							į		
l l							:		

QTY -041 ITEM P/N DESCRIPTION D3825-041 RIB ASSEMBLY (BASKET END) SPACER BUSHING BUSHING D2327-3 1 3 1 73759-1 4 1 03825-1 RIB

D3825-041 RIB ASSY (BASKET END)

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED CO-Y SUBJECT TO AMENDMENT WITHOUT NOTICE

A	NEW ISS	SUE		•	MB	08.09.23				
REV.			DESCRIPTION		BY	DATE				
DESIGN	V	ACE L	TD							
DRAWN	N	_5		HAWKESBURY, ONTARIO, CANADA						
CHECK	CHECKED 735		DRAWING NO.							
MFG. A	PPR.	M	D3825	D3825						
APPRO	IVED	1.4	TITLE		SCALE					
DE APPR.		RIB ASSY	RIB ASSY (BASKET END) NTS  COPYRIGHT © 2008 BY DART AEROSPACE LTD  146 COCUMENT OF PRIVIL AND CONF GENTLA OR IS SAME SED OF THE ARM PERSON HIS DATE OF THE PERSON HIS DATE OF THE ARM PERSON HIS DATE OF THE ARM P							
DATE 08.09.23									THE DOCUMENT IS PRIVATE AN NOT TO BE USED FOR ANY PLI	

NOTES:
1) MATERIAL: N/A
2) FINISH: N:DNE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.22 lbs
8) WELDING. PER DART QSI 004

8

7

Dail Aci	Jopade	, m.u								•
W/O:			WC	RK ORDER CHANGI	ES					
DATE	STEP	PRC	OCEDURE CHAI	NGE	E	Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
				,						
Part No	:	PAR #:	Fault Cate	gory:	NCR:	Yes N				
	R	esolution:	Disposition	1:	_ QA: N	I/C Clos	sed:	·	Date: _	
NCR:		1	WORK ORD	ER NON-CONFORMA	NCE (	NCR)				
DATE	STEP	Description of NC Section A	Corrective Action Initial Action Description Chief Eng Chief Er		on B	Sign & Date	Verification Section C		Approval Chief Eng	Approval QC Inspector
								<b></b>		
							1		•	

8 ulo 44108 D3825-1 RIB 0.94 D3759-1 BUSHING D2327-3 SPACER BUSHING 6.50 REF 11.00 REF D3825-041 RIB ASSY (BASKET END) DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN DRAWING NO. CHECKED REV. A D3825 MFG. APPR. SHEET 2 OF 3 APPROVED TITLE SCALE RIB ASSY (BASKET END)

COPYRIGHT 9 2008 BY DART AEROSPACE LTD

145 DODALENT OF PRINTE HAC CONFECUND, AND IS LAVE, GO ON THE EXPRESS DEBRISH
MOT TO BE USED GUARN PURPORES COPERED HOW DARK LESS TO NOW THE PRINCE
MOT TO BE USED GUARN PURPORES COPERED HOW DARK LESS TO NOW THE PRINCE
MOT TO BE USED GUARN PURPORES COPERED HOW DARK LESS TO NOW THE PRINCE
MOT TO BE USED GUARN PURPORES OF COPERED HOW DAY

TO BE USED GUARN PURPORES OF COPERED HOW DAY

THE PRINCE HAVE A DE APPR. DATE 08.09.23 8 5

, , , ,	Johaco	<del></del>								•	
W/O:			WO	RK ORDER CHANG	ES						
DATE	STEP	PRO	OCEDURE CHAN	NGE	Ву	C	ate	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No	:	PAR #:	Fault Categ	jory:	_ NCR: Y	es No	DQ.	A:	Date:		
	Re	solution:	Disposition	1:	QA: N/C	Close	ed:		Date: _		
NCR:			WORK ORDE	R NON-CONFORM	ANCE (N	CR)					
DATE	CTED	Description of NC			tion B		Verific	cation	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		gn & ate	Section C		Chief Eng	QC Inspector	
·											
	1								1		

8 Wollios φ0.375<sup>+0.020</sup><sub>-0.000</sub> THRU 6.500 Ø0.49 X 100° CSINK ON BOTH SIDES 0.375  $\phi$ 0.375 $^{+0.020}_{-0.000}$  THRU 0.75 REF 0.75 REF 0.065 REF 0.375 25.50 D3825-1 RIB NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL REF. DART SPEC. M304TS0.750W0.065
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.18 lbs DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D3825 MFG. APPR. SHEET 3 OF 3 TITLE APPROVED RIB ASSY (BASKET END) NT
COPYRIGHT © 2008 BY DARY AEROSPACE LTD
PHS COMMENTS OF THE ACCOUNTS AND ASSOCIATED THE ACCOUNTS OF TH DE APPR. DATE 08.09.23 8 3

Dail Ac	Ospace									* . · ·	
W/O:		,		WORK ORDER	CHANGES	·		•		•	
DATE	STEP		PR	OCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
			ţ.								
							Site		].		
		<b>,</b> , ,			,	,			7 7		
Part No	) <b>:</b>		_ PAR #:	Fault Category:	NCF	R: Yes	No <b>DQ</b>	<b>4:</b>	Date:		
	R	esolution:		Disposition:		QA: N/C Closed:					
		T		WORK OPPED NOV OO	VEODILANOE	/>!	<b>5</b> \				

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
DATE	STEP	Description of NC		Corrective Action Section B	Verification	Approval	Approval				
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	QC Inspecto			
		•									
·*											
					ė.	(3 *)					
					ì		:				
				and the second s							
		·									
					,						
	1	-4				170,					
				, single	<b>N</b>						